



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBT18660
Job Sheet 189210



Part No: RBT18660

Job Qty: 8 ea

Part Name: Tail Rotor Gear Box Drain Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/21/19

Job Tracking No:

Due Date: 3/13/19

Created By: Marie Lajeunesse

Type: Stock

Description: order 12244 ship 18 march

Note: DWG RBT18660 Rev.1 IPP Rev. A 19.01.04 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	8 pcs	3/13/19		0.00	1.60	Small Fab - 1		
							Small Fab - 2		MU
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	8 pcs	3/13/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
130	Packaging 3-1 - Stock - B4B	8 pcs	3/13/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		



Container No: S157150



Part: RBT18660

Job No: 189210

Serial No/Batch: S157150

Revision: 1

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 02/27/19

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					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140 QC21-FG	8 Ea	3/13/19	0.00 0.00		QC 21 - FG - 21	
					QC 21 - FG - 70	
					QC 21 - FG - 53	

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Part Op 100 - Small Fab - 1- Cut tube (2044T47) as per DWG 2- Assemble as per DWG. Install a 1.0" long, 0.38" OD, 0.25" ID Descriptions: piece of Stainless Steel into one end of the Kuri-Tech Hose until flush. Attach the modified end of the Kuri-Tech Hose to the Coupling before placing tool into packaging (if applicable).

110 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location:

140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
211 2044T47	Tube Ø1.09	8 ft (1 ea)	100-Small Fab - 1	5137333
49 2044T67	Cap Ø1.09	16 Ea (2 ea)	100-Small Fab - 1	5152045
44 51495K116	COUPLING 1/2" NCKL PLTD BRASS	8 Ea (1 ea)	100-Small Fab - 1	51517991 515122504 1X 5151940
57 9464K17	O-Ring, Ø1/16 X 0.364 I.D.	8 Ea (1 ea)	100-Small Fab - 1	5145163
K010-0608	Hose Ø1/2 OD x Ø3/8 ID	48 ft (6 ea)	100-Small Fab - 1	5145163 51054 96
PAD210	Foam Ø1 X 1	.6400 sf (.08 ea)	100-Small Fab - 1	5021250
146A RBT18660-1	Quill	8 pcs (1 ea)	100-Small Fab - 1	5151639
M304TR 0.375 W. 0.065		0.68 (0.085 ea)		5145223

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	2044T47	8	46	0
	2044T67	16	217	0
	51495K116	8	47	0
	9464K17	8	100	0
	K010-0608	48	345	0
	PAD210	1	4	0
	RBT18660-1	8	8	0

Part Specifications	
Specifications could not be found.	

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Created By: Marie Lajeunesse

Type: Stock

Description: order 12244 ship 18 march

Note: DWG RBT18660 Rev.1 IPP Rev. A 19.01.04 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	3/13/19	3/13/19	0.00	0.00	Start Up Small Fab-4		
100	Small Fab	1 pcs	3/13/19	3/13/19	0.00	0.20	Small Fab-9		
110	QC	1 pcs	3/13/19	3/13/19	0.00	0.00	QC5		
130	Packaging	1 pcs	3/13/19	3/13/19	0.00	0.00	Packaging3-2		
140	QC21-FG	1 Ea	3/13/19	3/13/19	0.00	0.00	QC21		

Part Op 100 - 1- Cut tube (2044T47) as per DWG 2- Assemble as per DWG. Install a 1.0" long, 0.38" OD, 0.25" ID piece of Descriptions: Stainless Steel into one end of the Kuri-Tech Hose until flush. Attach the modified end of the Kuri-Tech Hose to the Coupling before placing tool into packaging (if applicable).

130 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
2044T47	Tube Ø1.09	1 ft (1 ea)	90-Start up Operation	
2044T67	Cap Ø1.09	2 Ea (2 ea)	90-Start up Operation	
51495K116	COUPLING 1/2" NCKL PLTD BRASS	1 Ea (1 ea)	90-Start up Operation	
9464K17	O-Ring, Ø1/16 X 0.364 I.D.	1 Ea (1 ea)	90-Start up Operation	
K010-0608	Hose Ø1/2 OD x Ø3/8 ID	6 ft (6 ea)	90-Start up Operation	
PAD210	Foam Ø1 X 1	.0800 sf (.08 ea)	90-Start up Operation	
RBT18660-1	Quill	1 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	2044T47	1	29	0
	2044T67	2	113	0
	51495K116	1	43	0
	9464K17	1	100	0
	K010-0608	6	285	0
	PAD210	0	12	0
	RBT18660-1	1	0	0

Part Specifications

Specifications could not be found.

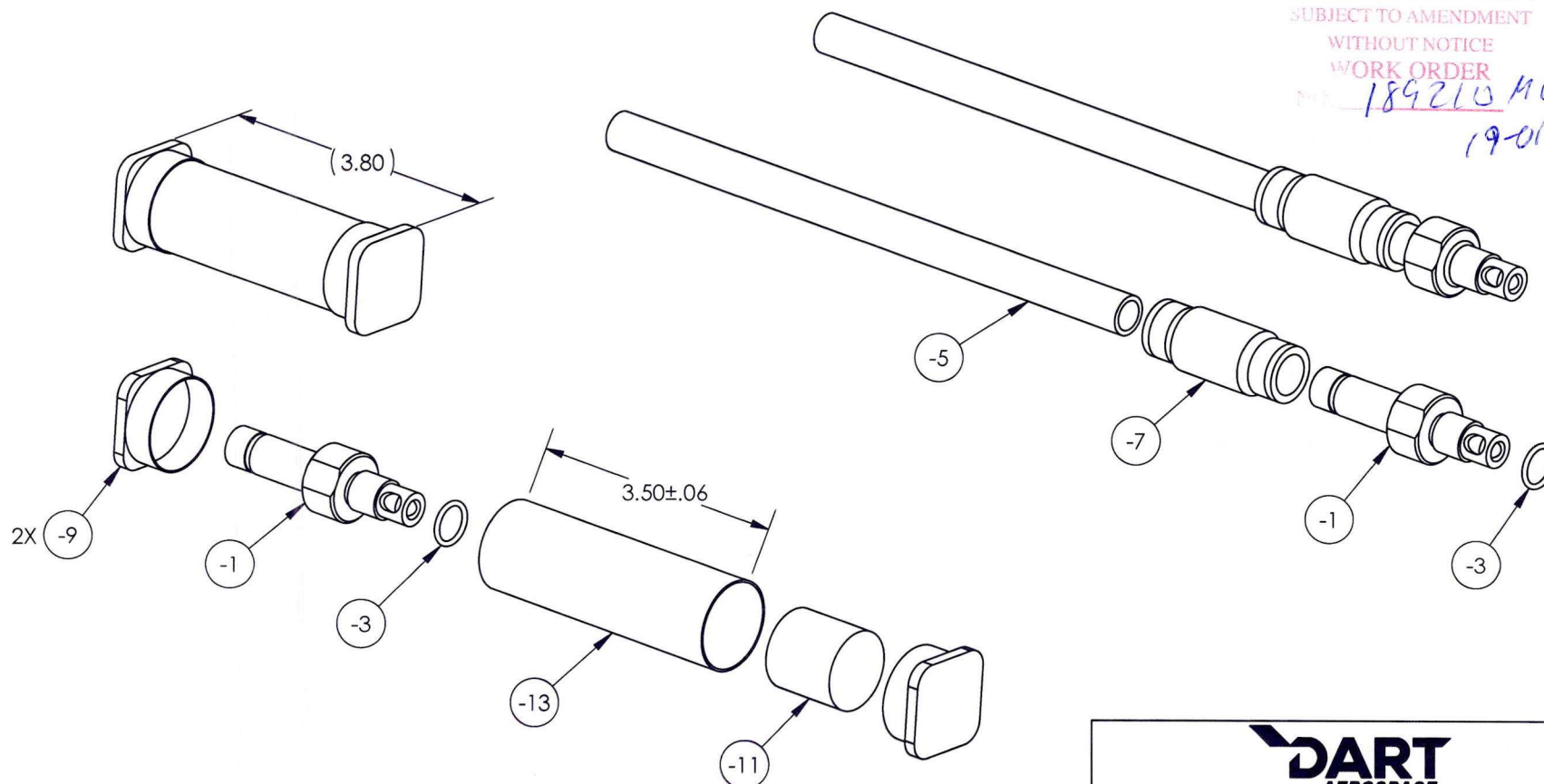
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REVISIONS				DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION				
1		RELEASED FOR PRODUCTION.		2/20/2015	RJC	PW

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WITHOUT NOTICE
WORK ORDER

189210 MLS
19-01-21



ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	QUILL	6061		2
		B/O	-3	1	O-RING	VITRON	Ø1/16 X .364 I.D. (MCMaster-CARR #9464K17)	1
		B/O	-5	1	HOSE	VINYL	Ø1/2 O.D. x Ø3/8 I.D. x 6ft KURI-TECH #K010-0608	1
		B/O	-7	1	COUPLING	NICKEL-PLATED BRASS	Ø1/2 MCMaster-CARR #51495K116	1
		B/O	-9	2	CAP	VINYL	Ø1.09 MCMaster-CARR #2044T67	1
		B/O	-11	1	FOAM	POLYESTER/POLYURETHANE	NEW PIG CORP. #PAD210	1
		B/O	-13	1	TUBE	POLYETHYLENE	Ø1.09 MCMaster-CARR #2044T47	1

DART AEROSPACE	
TITLE TAIL ROTOR DRAIN TOOL	
DWG NO. RBT18660	REV 1
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/8 ANGLES ± 5° 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	DRAWN BY: CLOUGH APPROVED: <i>D Walbrick</i> HEAT TREAT FINISH SPEC USED ON MODEL MD500
SCALE 1:2	DATE 2/18/2015
SHEET 1 OF 2	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					